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AMENDMENTS TO THE CLAIMS

WE CLAIM:

1. (Currently Amended) An easy open can end member comprising:
 - a central panel centered about a longitudinal axis having a peripheral edge and a tear panel defined by a fracture line, the tear panel retained to the central panel along a non-scored hinge region;
 - a curl defining an outer perimeter of the end member;
 - a circumferential chuckwall extending downwardly from the curl; and
 - a transition wall connecting the chuckwall with the peripheral edge of the central panel, the transition wall comprising a folded portion having a first end portion directly connected to the chuckwall and a second end portion connected to the central panel, the folded portion comprising an annular concave bend extending downwardly from the chuckwall, an annular convex bend extending upwardly from the annular concave bend, and a third bend joining the annular convex bend with the central panel wherein the third bend has a radius of curvature substantially defined by a lower extent of the annular concave bend.
2. (Original) The easy open can end member of Claim 1 wherein the folded portion extends outwardly relative to the longitudinal axis.
3. (Original) The easy open can member of Claim 2 wherein the folded portion further extends upwardly relative to the central panel.
4. (Previously Amended) The easy open can member of Claim 1 wherein the fold has a second end portion directly connected to the peripheral edge of the central panel.

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5. (Original) The easy open can member of Claim 1 wherein the chuckwall extends downwardly from the curl at an obtuse angle and the folded portion has a thickness that is substantially less than a length of the chuckwall.
6. (Cancelled)
7. (Cancelled)
8. (Cancelled)
9. (Cancelled)
10. (Currently Amended) The easy open can end member of Claim 9 1 wherein the annular concave annular portion includes an apex, the apex being in engagement with the peripheral edge of the central panel.
11. (Cancelled)

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12. (Currently Amended) An easy open can end member comprising:
a central panel centered about a longitudinal axis having a peripheral edge;
a curl defining an outer perimeter of the end member;
a circumferential chuckwall extending downwardly from the curl; and
a transition wall connecting the chuckwall with the peripheral edge of the central panel, the transition wall comprising a folded portion extending upwardly along the chuckwall, the folded portion comprising an annular concave bend extending downwardly from the chuckwall, an annular convex bend extending upwardly from the annular concave bend, and a third bend joining the annular convex bend with the central panel wherein the third bend has a radius of curvature substantially defined by a lower extent of the annular concave bend wherein the concave annular portion includes an apex in engagement with the peripheral edge of the central panel.
13. (Previously Amended) The easy open can member of Claim 12 wherein the folded portion extends outwardly relative to the longitudinal axis.
14. (Original) The easy open can member of Claim 13 wherein the fold has a length less than a length of the curl.
15. (Original) The easy open can member of Claim 12 wherein the chuckwall extends downwardly from the curl at an obtuse angle and the folded portion has a thickness that is substantially less than a length of the chuckwall.
16. (Cancelled)
17. (Cancelled)

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18. (Cancelled)
19. (Cancelled)
20. (Cancelled)
21. (Cancelled)
22. (Cancelled)
23. (Previously Amended) An easy open can end member comprising:
 - a central panel centered about a longitudinal axis having a peripheral edge, a public side and a product side;
 - a curl defining an outer perimeter of the end member;
 - a circumferential chuckwall extending downwardly from the curl; and
 - a transition wall connecting the chuckwall with the peripheral edge of the central panel, the transition wall comprising a fold including a concave annular portion having an apex engaging the peripheral edge of the central panel.
24. (Previously Amended) The easy open can end member of Claim 23 wherein the apex engages the public side of the peripheral edge of the central panel.
25. (Cancelled)

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26. (Original) The easy open can end member of Claim 23 wherein the fold further includes a convex annular portion joined to the concave annular portion and interconnected to the peripheral edge of the central panel.

27. (Original) The easy open can end member of Claim 26 wherein the fold further includes a third bend joining the convex annular portion to the peripheral edge of the central panel.

28. (Original) The easy open can end member of Claim 27 wherein the fold has a thickness less than a length of the chuckwall.

29. (Original) The easy open can end member of Claim 23 wherein the fold includes a portion extending outwardly relative to the longitudinal axis.

30. (Original) The easy open can end member of Claim 29 wherein the portion of the fold further extends upwardly relative to the central panel.

31. (Cancelled)

32. (Cancelled)

33. (Cancelled)

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34. (Original) An easy open can end member comprising:
a central panel centered about a longitudinal axis having a substantially planar peripheral edge, a public side and a product side;
a curl defining an outer perimeter of the end member;
a circumferential chuckwall extending downwardly from the curl; and
a transition wall connecting the chuckwall with the peripheral edge of the central panel, the transition wall comprising a fold including a first leg extending downwardly from the chuckwall to a concave annular portion having a first apex in engagement with the public side of the peripheral edge of the central panel, a second leg extending upwardly from the convex annular portion to a convex annular portion, and a third leg extending downwardly from the convex annular portion to a radial bend portion joined to the peripheral edge of the central panel.

35. (Currently Amended) A method for forming an easy open can end member, the method comprising the steps of:

providing a can end shell including a central panel centered about a longitudinal axis having a peripheral edge, a public side and a product side, a curl defining an outer perimeter of the can end shell, and a circumferential chuckwall extending downwardly from the curl joined to a transition wall; and

coining a hinge point between the chuckwall and the transition wall; and

reforming the transition wall to form a fold having a first end portion directly connected to the chuckwall and a second end portion connected to the central panel wherein the fold is initiated at the hinge point.

36. (Original) The method of Claim 35 further comprising the step of reforming the central panel to form a substantially planar peripheral edge.

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37. (Cancelled)

38. (Cancelled)

39. (Cancelled)

40. (Currently Amended) The method of Claim 35 ~~37~~ further comprising the step of providing relative movement between the central panel and the hinge point wherein the hinge point moves towards the peripheral edge of the central panel and the second end portion of the fold moves outwardly relative to the longitudinal axis.

41. (Previously Amended) The method of Claim 40 further comprising the step of providing relative movement between the second end portion of the fold and the central panel wherein the second end portion of the fold extends upwardly relative to the central panel.

42. (Previously Amended) The method of Claim 41 further comprising the step of continuing providing relative movement between the second end portion of the fold and the central panel until the second end portion of the fold is substantially perpendicular to the central panel.

43. (Previously Amended) The method of Claim 41 further comprising the step of continuing providing relative movement between the second end portion of the fold and the central panel until the hinge point engages the peripheral edge of central panel.